NOTE: The document identifier and heading has been changed on this page to reflect that this is a performance specification. There are no other changes to this document. The document identifier on subsequent pages has not been changed, but will be changed the next time this document is revised.

METRIC
MIL-PRF-24792
31 May 1995

PERFORMANCE SPECIFICATION

ADHESIVE, EPOXY, TWO PART, FIBER OPTICS

This specification is approved for use by the Naval Sea Systems Command, Department of the Navy, and is available for use by all Departments and Agencies of the Department of Defense.

1. SCOPE

1.1 Scope. This specification covers the requirements of a 100 percent solid epoxy adhesive for bonding optical fibers to metal and ceramic fiber optic connector and terminus ferrules.

2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Specifications, standards, and handbooks. The following specifications, standards, and handbooks form a part of this document to the extent specified herein. Unless otherwise specified, the issues of these documents are those listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto, cited in the solicitation (see 6.2).

SPECIFICATIONS

FEDERAL

QQ-A-250 - Aluminum and Aluminum Alloy Plate and Sheet: General Specification For.
QQ-A-250/4 - Aluminum Alloy, 2024, Plate and Sheet.

MILITARY

MIL-M-83522 - Connectors, Fiber Optic, Single Terminus, General Specification For.
MIL-C-83522/16 - Connector, Fiber Optic, Single Terminus, Plug, Adapter Style, 2.5 Millimeters Bayonet Coupling, Epoxy.

STANDARDS

FEDERAL

FED-STD-313 - Material Safety Data Transportation Data and Disposal Data for Hazardous Materials Furnished to Government Activities.

MILITARY

MIL-STD-129 - Marking for Shipment and Storage (Part 1 of 4).
MIL-STD-1344 - Test Methods for Electrical Connectors.
MIL-STD-1678 - Fiber Optics Test Methods and Instrumentation.
MIL-STD-2042 - Fiber Optic Topology Installation Standard Method for Naval Ships.
MIL-STD-2196 - Glossary, Fiber Optics.
MIL-STD-45662 - Calibration Systems Requirements.

(Unless otherwise indicated, copies of federal and military specifications, standards, and handbooks are available from the Defense Printing Services Detachment Office, Building 4D (Customer Service), 700 Robbins Avenue, Philadelphia, PA, 19111-5094.)

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Commander, Naval Sea Systems Command, SEA 03K12, 8531 Jefferson Davis Highway, Arlington, VA 22242-5160, by using the Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A
FSC 6070

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2.2 Non-Government publications. The following documents form a part of this document to the extent specified herein. Unless otherwise specified, the issues of the documents which are DoD adopted are those listed in the issue of the DODISS cited in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS are the issues of the documents cited in the solicitation (see 6.2).

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

ASTM D542	-	Standard Test Method for Index of Refraction of Transparent Organic Plastics.
ASTM D570	-	Standard Test Method for Water Absorption of Plastics.
ASTM D696	-	Standard Test Method for Coefficient of Linear Thermal Expansion of Plastics, Between -30°C and 30°C.
ASTM D1002	-	Standard Test Method for Strength Properties of Adhesives in Shear by Tension Loading (Metal to Metal).
ASTM D2240	-	Standard Test Method for Rubber Property - Durometer Hardness.
ASTM D2393	-	Standard Test Method for Viscosity of Epoxy Resins and Related Components.
ASTM D2471	-	Standard Test Method for Gel Time and Peak Exothermic Temperature of Reacting Thermosetting Resins.
ASTM D2566	-	Standard Test Method for Linear Shrinkage of Thermosetting Casting Systems During Cure.
ASTM D3418	-	Standard Test Method for Transition Temperatures of Polymers by Thermal Analysis.
ASTM E595	-	Standard Test Method for Total Mass Loss and Collected Volatile Condensible Materials from Outgassing in a Vacuum Environment

(Application for copies should be addressed to the American Society for Testing and Materials, 1918 Race Street, Philadelphia, PA 19103.)

(Non-Government standards and other publications are normally available from the organizations that prepare of distribute the documents. These documents may also be available in or through libraries or other informational services.)

2.3 Order of precedence. In the event of a conflict between the text of this document and the references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

3. REQUIREMENTS

3.1 First article. When specified (see 6.2), a sample shall be subjected to first article inspection (see 6.3) in accordance with 4.4.

3.2 Materials. The cured adhesive material shall not produce toxic, corrosive, or explosive byproducts. For safety of the material, all materials are subject to a toxicological and formulations review and inspection by the Government.

3.2.1 Material safety data sheet (see 6.7). The contracting activity shall be provided a material safety data sheet (MSDS) at the time of contract award. The MSDS shall be provided in accordance with the requirements of FED-STD-313. The MSDS shall be included with each shipment of the material covered by this specification.

3.3 Composition. The adhesive shall be a two component, 100 percent solid, epoxy adhesive.

3.4 Performance requirements. The performance requirements shall be defined in terms of the mechanical, environmental, and chemical properties.

3.4.1 Viscosity (see 4.6.1). Each adhesive component shall have a viscosity as specified in table I.

TABLE I. Adhesive viscosity.

Item	Viscosity (cps) at +25°C
Part A (resin)	1,000 to 10,000
Part B (hardener)	300 to 5,000

3.4.2 Shelf life (see 4.6.2). The unmixed adhesive components shall have a shelf life not less than 24 months at +25°C ±5°C (see 6.6). The 24 month period commences on the date of the adhesive component manufacture. The unmixed adhesive components shall meet the requirements of 3.4.1. When cured in-

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accordance with 3.5.5, the adhesive shall meet the requirements of 3.4.7, 3.4.8, 3.4.9, and 3.4.17 (space application only).

3.4.3 Storage temperature (see 4.6.2). The unmixed adhesive shall be capable of storage at temperatures from -40°C to +85°C. After storage, the unmixed adhesive components shall meet the requirements of 3.4.1. When cured in accordance with 3.4.5, the adhesive shall meet the requirements of 3.4.7, 3.4.8, and 3.4.9.

3.4.4 Pot life (see 4.6.3). The mixed adhesive shall have a working life not less than 30 minutes at +25°C ±5°C. Throughout the working life, the adhesive shall be able to be dispensed through a syringe needle with a 0.91 mm (.04 inch) outer diameter.

3.4.5 Cure schedule (see 4.6.4). The mixed adhesive shall meet the requirements of 3.4.6, 3.4.7, 3.4.8, 3.4.9, 3.4.10, 3.4.11, 3.4.12, 3.4.13, and 3.4.17 (space application only) when cured as specified (see 6.5).

3.4.6 Linear shrinkage (see 4.6.5). The adhesive shall have a linear shrinkage of not greater than 1 percent when cured in accordance with 3.4.5.

3.4.7 Hardness (see 4.6.6). When cured in accordance with 3.4.5, the adhesive shall have a Shore D hardness not less than 65.

3.4.8 Bond strength (see 4.6.7). When cured in accordance with 3.4.5, the adhesive shall have a bond strength not less than 10.3 MPa (1,500 psi) at a temperature of +25°C ±5°C.

3.4.9 Glass transition temperature (see 4.6.8). When cured in accordance with 3.4.5, the adhesive shall have a glass transition temperature not less than +85°C.

3.4.10 Index of refraction (see 4.6.9). When cured in accordance with 3.4.5, the adhesive shall have an index of refraction not less than 1.500.

3.4.11 Coefficient of linear thermal expansion (see 4.6.10). When cured in accordance with 3.4.5, the adhesive shall have a coefficient of linear thermal expansion not greater than 85 x 10^{-6} mm/°C.

3.4.12 Temperature (see 4.6.10). When cured in accordance with 3.4.5 and after exposure to non-operating temperature extremes between -40°C and +85°C, the adhesive shall meet the requirements of 3.4.11 when exposed to operating temperature extremes between -28°C and +85°C.

3.4.13 Water absorption (see 4.6.11). When cured in accordance with 3.4.5, the adhesive shall absorb an amount of water not greater than 0.5 percent of the adhesive weight.

3.4.14 Identification and marking (see 4.6.12). All containers shall be marked in accordance with MIL-STD-129. The markings shall be permanent, clearly visible, and legible. Marking information shall include the PIN, CAGE code, manufacturer's name, lot number, and date of manufacture.

3.4.15 Workmanship (see 4.6.13). All adhesive material shall be uniform in quality and free from foreign material or any defects detrimental to the fabrication or performance of the adhesive.

3.4.16 Connector compatibility (see 4.6.14). The adhesive shall securely hold an optical fiber within a fiber optic connector. The adhesive shall restrict axial movement of the optical fiber with respect to the fiber optic connector ferrule to be less than ± 0.2 µm.

3.4.17 Outgassing (see 4.6.15) (space applications only). The cured adhesive shall have a total mass loss (TML) of ≤ 1 percent and a collected volatile condensible material (CVCM) of ≤ 0.1 percent.

3.5 Shipping. Adhesive material shall not be shipped on any order to this specification if the shipping date is greater than 90 days from the manufacturing date.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of all inspection requirements (examinations and tests) as specified herein. Except as otherwise specified in the contract or purchase order, the contractor may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in this specification where such inspections are deemed necessary to ensure supplies and services conform to prescribed requirements.

4.1.1 Responsibility for compliance. All items shall meet all requirements of sections 3 and 5 herein. The inspections set forth in this specification shall become a part of the contractor's overall inspection system or quality program. The absence of any inspection requirements in the specification shall not relieve the contractor of the responsibility of ensuring that all products or supplies submitted to the

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Government for acceptance comply with all requirements of the contract. Sampling inspection, as part of manufacturing operations, is an acceptable practice to ascertain conformance to requirements, however, this does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to accept defective material.

4.2 Classification of inspections. The inspection requirements specified herein are classified as follows:

a. First contract inspection (see 4.3).

b. First article inspection (see 4.4).

c. Quality conformance inspection (see 4.5).

4.3 First contract inspection. First contract inspection (see 6.4.1) is applicable only on the first acquisition of a particular product under this specification. First contract inspections (see 6.4.1) shall consist of the tests listed in table II and shall be conducted in conjunction with first article inspections. The material submitted for testing shall be representative of the production process.

TABLE II. First contract inspection.

Inspection	Requirement	Test	Sample size
Identification and marking	3.4.14	4.6.12	All units
Index of refraction	3.4.10	4.6.9	1/
Water absorption	3.4.13	4.6.11	1/
Connector compatibility	3.4.16	4.6.14	3 connector assemblies

1/ Three specimens shall be used from units selected at random from the first contract sample. The specimens shall have been cured in accordance with 3.4.5.

4.3.1 Sample. The sample submitted shall be a number of units of the same PIN sufficient to complete all of the inspections.

4.3.2 Inspection routine. The sample shall be subjected to the inspections specified in table II in the order shown. The tests identified in table II may be performed at the same time as the tests identified in table III.

4.3.3 Failures. One or more failures shall be sufficient cause for refusal to grant approval. Products that have not passed first contract inspection shall not be delivered.

4.4 First article inspection. First article inspection shall consist of all the tests listed in table III. The material submitted for testing shall be representative of the production process.

4.4.1 Sample. The sample submitted shall be a number of units of the same PIN sufficient to complete all of the inspections.

4.4.2 Inspection routine. The sample shall be subjected to the inspections specified in table III in the order shown.

4.4.3 Failures. One or more failures shall be sufficient cause for refusal to grant first article approval. When first article test units are taken from a larger lot, and the first article is disapproved, none of the units from that lot shall be delivered.

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TABLE III. First article inspection.

Inspection	Requirement	Test	Sample size
Identification and marking	3.4.14	4.6.12	All units
Workmanship	3.4.15	4.6.13	All units
Viscosity	3.4.1	4.6.1	1/
Shelf life	3.4.2	4.6.2	2/
Storage temperature	3.4.3	4.6.2	3/
Pot life	3.4.4	4.6.3	1/
Cure schedule	3.4.5	4.6.4	4/
Linear shrinkage	3.4.6	4.6.5	5/
Hardness	3.4.7	4.6.6	5/
Bond strength	3.4.8	4.6.7	5/
Glass transition temperature	3.4.9	4.6.8	5/
Coefficient of linear thermal expansion	3.4.11	4.6.10	5/
Temperature	3.4.12	4.6.10	6/
Outgassing	3.4.17	4.6.15	1/

1/ Three specimens shall be used from units selected at random from the first article sample.
2/ Twelve specimens shall be used from units selected at random from the first article sample.
3/ The same specimens shall be used as are used in the shelf life inspection.
4/ Fifteen specimens shall be used from units selected at random from the first article sample.
5/ Three specimens shall be used selected from the specimens used in the cure schedule inspection.
6/ The same specimens shall be used as are used in the coefficient of linear thermal expansion inspection.

4.5 Quality conformance inspection. Quality conformance inspection shall consist of the inspections and tests specified for group A inspection (table IV), group B inspection (table V) and group C inspection (table VI), as specified (see 6.2).

4.5.1 Group A inspection. Group A inspection shall consist of the tests listed in table IV conducted in the order shown.

TABLE IV. Group A inspection.

Inspection	Requirement	Test
Identification and marking	3.4.14	4.6.12

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4.5.1.1 Sampling plan. Group A inspections shall be performed on 100 percent of the product supplied under this specification. There shall be no failures.

4.5.1.2 Rejected lots. If an inspection lot is rejected, the contractor may rework it to correct the defects, or screen out the defective units (if applicable), and resubmit them for inspection. Such lots shall be separate from new lots, and shall be clearly identified as reinspected lots.

4.5.1.3 Disposition of sample units. Samples that have failed group A inspection shall not be delivered or submitted for group B testing.

4.5.2 Group B inspection. Group B inspection shall consist of the tests listed in table V conducted in the order shown. Group B inspections shall be made on sample units that have passed group A inspection.

TABLE V. Group B inspection.

Inspection	Requirement	Test
Workmanship	3.4.15	4.6.13
Cure schedule	3.4.5	4.6.4
Hardness	3.4.7	4.6.6
Bond strength	3.4.8	4.6.7

4.5.2.1 Sampling plan. Three sample units shall be selected from each lot of material supplied under this specification. There shall be no failures.

4.5.2.2 Rejected lots. If an inspection lot is rejected, the contractor may rework it to correct the defects, or screen out the defective units (if applicable), and resubmit them for inspection. Such lots shall be separate from new lots, and shall be clearly identified as reinspected lots.

4.5.2.3 Disposition of sample units. Samples that have failed group B inspection shall not be delivered or submitted for group C testing.

4.5.3 Periodic inspection. Periodic inspection shall consist of group C inspection. Except where the results of these inspections show noncompliance with the applicable test requirements (see 4.5.3.1.4), delivery of products which have passed group B shall not be delayed pending the results of these first article verification inspections.

4.5.3.1 Group C inspection. Group C inspection shall consist of the inspections specified in table VI in the order shown. Group C inspections shall be made on units that have passed the group B inspection.

TABLE VI. Group C inspection.

Inspection	Requirement	Test
Viscosity	3.4.1	4.6.1
Shelf life	3.4.2	4.6.2
Storage temperature	3.4.3	4.6.2
Pot life	3.4.4	4.6.3
Linear shrinkage	3.4.6	4.6.5
Glass transition temperature	3.4.9	4.6.8
Coefficient of linear thermal expansion	3.4.11	4.6.10
Temperature	3.4.12	4.6.10
Outgassing	3.4.17	4.6.15

4.5.3.1.1 Sampling plan. Every 36 months, a number of units of the same PIN, sufficient to complete all of the inspections, which have passed group B inspection shall be selected.

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4.5.3.1.2 Failures. If one or more specimen or sample units fail to pass group C inspection, the sample shall be considered to have failed.

4.5.3.1.3 Disposition of sample units. Sample units that have been submitted to group C inspection shall not be delivered.

4.5.3.1.4 Noncompliance. If a sample fails to pass group C inspection, the contractor shall notify the contracting activity of the failure and take corrective action on the materials and processes, or both, as warranted, and on all units of product which can be corrected and which were manufactured under essentially the same conditions, with essentially the same materials, processes, and which are considered subject to the same failure. Acceptance of the product shall be discontinued until corrective action, acceptable to the contracting activity has been taken. After the corrective action has been taken, group C inspection shall be repeated on additional sample units (all inspection tests or the inspection test which the original sample failed, at the option of the contracting activity). Group A and group B inspections may be reinstituted; however, final acceptance shall be withheld until the group C inspection has shown that the corrective action was successful. In the event of failure after reinspection, information concerning the failure and the corrective action taken shall be furnished to the contracting activity.

4.6 Methods of Inspection.

4.6.1 Viscosity (see 3.4.1). Each adhesive component and the mixed adhesive shall be tested, using a viscometer, in accordance with ASTM D 2393 and table VII.

TABLE VII. Viscometer specifications.

Item tested	Spindle	Speed
Resin	7	20
Hardener	5	4

4.6.2 Accelerated shelf life/storage temperature (see 3.4.2 and 3.4.3). The unmixed adhesive components shall be exposed to a temperature of +85°C ±2°C for 150 hrs. After exposure, part of the unmixed adhesive components shall be subjected to the test specified in 4.6.1. The remainder shall be cured in accordance with 3.4.5, and subjected to the tests specified in 4.6.6, 4.6.7, 4.6.8, and 4.6.15 (space application only).

4.6.3 Pot life (see 3.4.4). One hundred grams of adhesive components shall be mixed and tested in accordance with ASTM D 2471. Four grams of the mixed material shall be inserted into a syringe and the requirements of 3.4.4 periodically verified.

4.6.4 Cure schedule (see 3.4.5). The adhesive components shall be mixed and cured in accordance with 3.4.5 (see 6.5). The quantities of adhesive cured shall be as required to complete the tests specified in 4.6.5 through 4.6.11. During cure the adhesive shall be subjected to the test specified in 4.6.5. The cured adhesive shall then be subjected to the tests specified in 4.6.6 through 4.6.11 and 4.6.15 (space application only).

4.6.5 Linear shrinkage (see 3.4.6). The adhesive shall be tested in accordance with ASTM D 2566 or equivalent.

4.6.6 Hardness (see 3.4.7). A 24 gm slab of cured adhesive shall be tested in accordance with ASTM D 2240.

4.6.7 Bond strength (see 3.4.8). The cured adhesive shall be tested in accordance with ASTM D 1002 using acid etched aluminum bars (QQ-A-250/4). The thickness of adhesive material between the two aluminum bars shall be 0.13 ±0.03 mm (0.01 ±.001 inch).

4.6.8 Glass transition temperature (see 3.4.9). The cured adhesive shall be tested in accordance with ASTM D 3418 using a Differential Scanning Calorimeter, or equivalent.

4.6.9 Index of refraction (see 3.4.10). The cured adhesive shall be tested in accordance with ASTM D 542 or equivalent.

4.6.10 Coefficient of linear thermal expansion (see 3.4.11 and 3.4.12). The cured adhesive shall initially be soaked at both -40°C and +85°C for one hour. The cured adhesive shall then be tested in accordance with ASTM D 696 or equivalent. The test shall be performed at 11 equally spaced temperatures spanning the operating temperature range specified in 3.4.12.

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4.6.11 Water absorption (see 3.4.13). The cured adhesive shall be tested for 24 hours in accordance with ASTM D 570 or equivalent.

4.6.12 Identification and marking (see 3.4.14). The adhesive containers shall be visually examined for conformance with the requirements of 3.4.14.

4.6.13 Workmanship (see 3.4.15). The adhesive components shall be visually examined for conformance with the requirements of 3.4.15.

4.6.14 Connector compatibility (see 3.4.16). The adhesive components shall be mixed and used in the assembly of a 62.5/125/900 µm optical fiber into a MIL-C-83522/16 fiber optic connector. The connector shall be assembled in accordance with MIL-STD-2042 except that the connector shall not be crimped to the 900 µm fiber. The connector assembly shall be exposed to the tests specified in 4.6.14.1 through 4.6.14.3 in the order listed.

4.6.14.1 Thermal shock. The connector assembly shall be tested for 5 cycles in accordance with MIL-STD-1344, method 1003. The high and low temperature extremes shall be -40°C and +85°C, respectively. After the test the connector assembly shall be examined for fiber pistoning using a profilometer or an optical interferometer.

4.6.14.2 Humidity cycling. The connector assembly shall be tested in accordance with MIL-STD-1678, method 4030.

4.6.14.3 Fiber retention. The connector assembly shall be tested by applying a tensile force of 14.0 N (3.1 pounds) on the 900 µm fiber for one minute. After the test the connector assembly shall be examined for fiber pistoning using a profilometer or an optical interferometer.

4.6.15 Outgassing (see 3.4.17). The cured adhesive shall be tested in accordance with ASTM E 595.

5. PACKAGING

(Packaging requirements specified herein apply only for direct Government procurement.)

5.1 Packaging requirements. The adhesive components shall be packaged as required (see 6.2) and packed to ensure that the material is received in undamaged condition when shipped by a common carrier.

6. NOTES

(This section contains information of a general or explanatory nature which may be helpful, but is not mandatory.)

6.1 Intended use. The adhesive covered by this specification is intended for use with fiber optic connectors in fixed plant, tactical, shipboard, aerospace, and spaceflight applications.

6.2 Acquisition requirements. Acquisition documents must specify the following:

a. Title, number, and date of this specification.

b. Issue of DODISS to be cited in the solicitation, and if required, the specific issue of the individual documents referenced (see 2.1).

c. Type of adhesive primary packaging required (cans; tubes; premeasured 2 gm, 4 gm, or 8 gm packages; frozen premixed).

d. Type of adhesive secondary packaging required (none, airtight bags, airtight canisters).

6.3 First article. When first article inspection is required, the items should be a first article sample. The first article should consist of a minimum of 4 units. The contracting officer should also include specific instructions in acquisition documents regarding arrangements for examinations, approval of first article test results, and disposition of first articles. Invitations for bids should provide that the Government reserves the right to waive the requirement for samples for first article inspection to those bidders offering a product which has been previously acquired or tested by the Government, and that bidders offering such products, who wish to rely on such production or test, must furnish evidence with the bid that prior Government approval is presently appropriate for the pending contract. Unless specifically requested to do so in the solicitation, bidders should not submit alternate bids.

6.4 Definitions. Definitions of terms shall be in accordance with MIL-STD-2196 and the following.

6.4.1 First contract. The first contract is considered to be the first contract under which a manufacturer's material is supplied to any acquiring activity under this specification.

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6.4.1 First contract inspection. First contract inspections are inspections required in addition to first article inspections for the first contract in which this specification is invoked. First contract inspections are intended to evaluate basic material properties that are primarily a function of the product formulation, not the product manufacturing process.

6.5 Part or Identifying Number (PIN). The PIN for this adhesive shall consist of the basic specification number, a one character cure schedule identifier, and an optional space flight application identifier as shown in the following example:

M24792 - A S

Basic specification number

Cure schedule identifier (see table VIII)

Space flight application

TABLE VIII. Cure schedule identifiers.

Cure schedule identifier	Cure schedule
A	20 ±1 minutes at +120°C ±3°C
B	10 ±1 minutes at +100°C ±3°C
C	2 ±1 minutes at +25°C ±3°C

6.6 Shelf life. Products acquired to this specification should not be used for fiber optic termination purposes under any conditions if the date of manufacture has passed by more than 24 months. If products acquired to this specification are exposed to temperatures higher than the temperatures specified in 3.4.2, the shelf life may be decreased and the manufacturer should be contacted to determine the appropriate shelf life under the actual storage conditions. Storage conditions should never exceed the temperature specified in 4.6.2.

6.7 MSDSs. Contracting officers will identify those activities requiring copies of completed MSDSs prepared in accordance with FED-STD-313. The pertinent Government mailing addresses for submission of data are listed in FED-STD-313.

6.8 Subject term (key word) listing.

Bonding optical fibers
Connectors
Cured adhesive components
Epoxy adhesive
Shelf life

Custodians:
Army - CR
Navy - SH
NASA - NA

Review activities:
Army - MI
Navy - AS, EC, YD
Air Force - 17, 19, 80, 85, 99
DLA - ES

Preparing activity:
Navy - SH

Agent:
DLA - ES

(Project 6070-N002-1)

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STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

INSTRUCTIONS

1. The preparing activity must complete blocks 1, 2, 3, and 8. In block 1, both the document number and revision letter should be given.

2. The submitter of this form must complete blocks 4, 5, 6, and 7.

3. The preparing activity must provide a reply within 30 days from receipt of the form.

NOTE: This form may not be used to request copies of documents, nor to request waivers, or clarification of requirements on current contracts. Comments submitted on this form do not constitute or imply authorization to waive any portion of the referenced document(s) or to amend contractual requirements.

I RECOMMEND A CHANGE:	1. DOCUMENT NUMBER MIL-A-24792	2. DOCUMENT DATE (YYMMDD) 95/05/31

3. DOCUMENT TITLE
ADHESIVE, EPOXY, TWO PART, FIBER OPTICS

4. NATURE OF CHANGE (Identify paragraph number and include proposed rewrite, if possible. Attach extra sheets as needed.)

5. REASON FOR RECOMMENDATION

6. SUBMITTER

a. NAME (Last, First, Middle Initial)	b. ORGANIZATION	
c. ADDRESS (Include Zip Code)	d. TELEPHONE (Include Area Code) (1) Commercial (2) AUTOVON (If applicable)	7. DATE SUBMITTED (YYMMDD)

8. PREPARING ACTIVITY TECHNICAL POINT OF CONTACT (POC):

a. NAME MS. Karen Long SEA 03K1222	b. TELEPHONE (Include Area Code) (1) Commercial (703) 602-7240 X223 (2) AUTOVON 332-7240 X223
c. ADDRESS (Include Zip Code) Commander, Naval Sea Systems Command, SEA 03R42, 2531 Jefferson Davis Hwy., ARL, VA 22242-5160	IF YOU DO NOT RECEIVE A REPLY WITHIN 45 DAYS, CONTACT: Defense Quality and Standardization Office 5203 Leesburg Pike, Suite 1403, Falls Church, VA 22041-3466 Telephone (703) 756-2340 AUTOVON 289-2340

PLEASE ADDRESS ALL CORRESPONDENCE:

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